

REMARKS

Claims 21-32 and 34-39 were pending in this application.

Claims 26-32 have been withdrawn as being directed to non-elected species of claims.

Claims 21-25 and 34-39 have been rejected.

Claims 21-32 and 34-39 have been amended as shown above.

Claims 40-54 have been added.

Claims 21-32 and 34-54 are now pending in this application.

Reconsideration and full allowance of Claims 21-32 and 34-54 are respectfully requested.

I. ALLOWABLE CLAIMS

The Applicant thanks the Examiner for the indication that Claims 36-39 would be allowable if rewritten or amended to overcome a § 112 rejection. As noted below, Claims 36-39 have been amended to (among other things) resolve the § 112 issue. The Applicant respectfully submits that Claims 36-39 as amended remain in condition for allowance. Accordingly, the Applicant respectfully requests full allowance of Claims 36-39.

II. OBJECTION TO SPECIFICATION

The Office Action objects to the specification because “page 10 was not supplied with the original application[.]” (*Office Action, Page 2, Section 1*).

A copy of this patent application was retrieved from the USPTO Public PAIR system on April 15, 2008. The copy of the application as retrieved is included in the Appendix. This copy

of the patent application includes page 10 of the specification. A review of all documents in this case from the USPTO Public PAIR system does not indicate that page 10 of the originally-filed specification was ever included in a response or other paper sent to the Patent Office after the original filing. In fact, it does not appear as if any amendments have ever been made to the specification of this patent application. While the text contained on page 10 of the specification was reproduced in a response filed in February 2006, the text from page 10 was included within the actual body of that response (not on a separate page separate from the February 2006 response).

As a result, page 10 of the originally-filed specification as retrieved from the USPTO Public PAIR system on April 15, 2008 must have been submitted with the original filing. Accordingly, the Applicant respectfully requests withdrawal of the objection to the specification.

III. OBJECTION TO PRIOR AMENDMENT UNDER 35 U.S.C. § 132

The Office Action objects to a prior amendment under 35 U.S.C. § 132(a) as containing new matter. The Applicant has amended the claims as shown above. Among other things, these amendments resolve the new matter objection.

IV. REJECTION UNDER 35 U.S.C. § 112

The Office Action rejects Claims 21-25 and 34-39 under 35 U.S.C. § 112, first paragraph, as failing to comply with the written description requirement. The Applicant has amended the claims as shown above. Among other things, these amendments resolve the § 112 rejection.

V. **REJECTION UNDER 35 U.S.C. § 103**

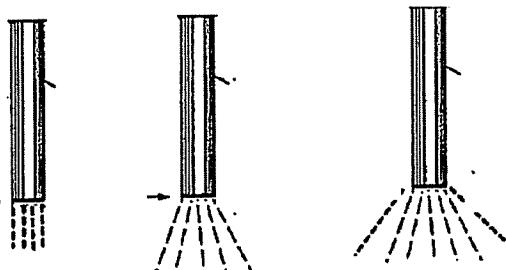
The Office Action rejects Claims 21-25, 34, and 35 under 35 U.S.C. § 103(a) as being unpatentable over U.S. Patent No. 4,152,202 to DeLigt (“*DeLigt*”). This rejection is respectfully traversed.

In *ex parte* examination of patent applications, the Patent Office bears the burden of establishing a *prima facie* case of obviousness. (*MPEP* § 2142; *In re Fritch*, 972 F.2d 1260, 1262, 23 U.S.P.Q.2d 1780, 1783 (Fed. Cir. 1992)). The initial burden of establishing a *prima facie* basis to deny patentability to a claimed invention is always upon the Patent Office. (*MPEP* § 2142; *In re Oetiker*, 977 F.2d 1443, 1445, 24 U.S.P.Q.2d 1443, 1444 (Fed. Cir. 1992); *In re Piasecki*, 745 F.2d 1468, 1472, 223 U.S.P.Q. 785, 788 (Fed. Cir. 1984)). Only when a *prima facie* case of obviousness is established does the burden shift to the Applicant to produce evidence of nonobviousness. (*MPEP* § 2142; *In re Oetiker*, 977 F.2d 1443, 1445, 24 U.S.P.Q.2d 1443, 1444 (Fed. Cir. 1992); *In re Rijckaert*, 9 F.3d 1531, 1532, 28 U.S.P.Q.2d 1955, 1956 (Fed. Cir. 1993)). If the Patent Office does not produce a *prima facie* case of unpatentability, then without more the Applicant is entitled to grant of a patent. (*In re Oetiker*, 977 F.2d 1443, 1445, 24 U.S.P.Q.2d 1443, 1444 (Fed. Cir. 1992); *In re Grabiak*, 769 F.2d 729, 733, 226 U.S.P.Q. 870, 873 (Fed. Cir. 1985)).

The Office Action continues to make a fundamental misstatement regarding the disclosure of *DeLigt* when rejecting Claim 21. The Office Action asserts that *DeLigt* specifically teaches that:

each nozzle can be controlled to vary the magnitude and then the nozzles are adjusted to change the fan spray, see paragraph bridging columns 4 and 5. The

fan spray changes reads in the change of shape, since changing the width of the spray changes the shape, see figure below.



Different fan sprays = different shape

(Office Action, Page 4).

DeLigt does not in any way teach that “nozzles are adjusted to change the fan spray.” In fact, *DeLigt* specifically teaches the exact opposite. *DeLigt* specifically notes that one objective of its invention is to provide a spray system having a variable flow rate “without affecting the spray impact velocity or fan width.” (Col. 3, Lines 59-61) (underlining added). *DeLigt* also specifically recites in its claims that each nozzle of a fluid spray station is sized to discharge a flow rate of fluid “at substantially the same velocity and spray width upon impact ... as such other nozzles in said [fluid spray] station.” (Col. 7, Lines 65-68) (underlining added).

DeLigt is crystal clear – the entire purpose of *DeLigt* is to provide spray nozzles that have the same spray width. The statement in the Office Action that the nozzles in *DeLigt* are adjusted to change their fan sprays is factually incorrect.

Moreover, the cited portion of *DeLigt* relied upon by the Office Action (the paragraph bridging columns 4 and 5) is reproduced in its entirety below:

Downstream of each valve 31, 32 and 33 are spray nozzles 35, 36

and 37, respectively. These nozzles emit a fan-spray pattern and are positioned above the plane of the fourdrinier pond at a height which corresponds to the angular spread of the spray fan and the desired impact velocity. The angular spread of the spray fan is also determinative of lateral spacing between CD adjacent spray stations, the spacing being such to provide an approximately one-half inch overlap of adjacent spray fans.

(*Col. 4, Line 67 – Col. 5, Line 8*).

This portion of *DeLigt* merely notes that the nozzles emit “a fan-spray pattern” and that the positions and spacing of the nozzles depend on the “angular spread” of the spray fans. Absolutely nothing here mentions or even implies the “adjustment” of the “fan-spray patterns” in any way whatsoever. The Office Action’s continued reliance of this portion of *DeLigt* as supporting the adjustment of the nozzles’ spray fans is therefore clearly improper.

DeLigt does note in its background section that the technique disclosed in a prior patent (U.S. Patent No. 3,989,085) controlled nozzles via “flow throttling,” which resulted in undesirable variations (50% or more) in spray fan width. (*Col. 3, Lines 6-52*). The whole purpose of the system in *DeLigt* was to allow variable flow rates while avoiding this undesirable variation in spray fan width. To the extent the Office Action might rely on the noted problems with the prior patent, nothing in *DeLigt* indicates that a “first control action” with a “magnitude” and a “second control action” that manipulates a “cross-directional shape” are both controlled in this prior patent.

The Office Action’s statement that the nozzles of *DeLigt* could be moved is unclear. If the nozzles of *DeLigt* move sideways with respect to a web pond 30, the “cross-directional shape” of the spray fan from each nozzle would not change. Also, nothing in *DeLigt* indicates

that moving the nozzles closer to the web pond 30 is necessary or even desirable. In fact, moving the nozzles closer to the web pond 30 would cause the spray fans of the nozzles to no longer overlap, which is the desired outcome in *DeLigt*. (See, e.g., Col. 3, Lines 50-52; Col. 5, Lines 4-8).

For these reasons, the Office Action fails to establish a *prima facie* case of obviousness against Claim 21 and its dependent claims.

Claims 22-25, 34, and 35 depend from Claim 21 and are patentable over *DeLigt* due to their dependence from an allowable base claim and in light of their own recitations. For example, Claims 22-25 recite steam actuators, which are never disclosed or suggested in *DeLigt*. Claim 22 recites an outlet chamber in a steam actuator, where dimensions of the outlet chamber are adjustable to control the cross-directional shape of a control action. *DeLigt* contains no mention of adjusting the dimensions of an outlet chamber of a steam actuator. Claim 23 recites at least one baffle plate, which is movable to control the cross-directional position and the dimensions of an outlet chamber. *DeLigt* contains no mention of any baffle plate that can change the cross-directional position or the dimensions of an outlet chamber of a steam actuator. Claim 24 recites a screen plate with openings and at least one movable plate, where movement of the at least one movable plate fully or partially obstructs the openings in the screen plate. *DeLigt* contains no mention of any screen plate with openings or of any movable plate that operates in this manner. Claim 25 recites at least one air jet that is dischargable to control a shape of a steam flow. *DeLigt* contains no mention of any air jet used to control the shape of a steam flow.

For these reasons, the Office Action fails to establish a *prima facie* case of obviousness against Claims 22-25, 34, and 35.

Accordingly, the Applicant respectfully requests withdrawal of the § 103 rejection and full allowance of Claims 21-25, 34, and 35.

VI. NEW CLAIMS

The Applicant has added new Claims 40-54. The Applicant respectfully submits that no new matter has been added. At a minimum, the Applicant respectfully submits that Claims 40-54 are patentable for one or more reasons discussed above and/or the indicated allowability of Claims 36-39. The Applicant respectfully requests entry and full allowance of Claims 40-54.

SUMMARY

The Applicant respectfully asserts that all pending claims in this application are in condition for allowance and respectfully requests full allowance of the claims.

If any issues arise or if the Examiner has any suggestions for expediting allowance of this application, the Applicant respectfully invites the Examiner to contact the undersigned at the telephone number indicated below or at *wmunck@munckbutrus.com*.

The Applicant has included the appropriate fee to cover the cost of this Amendment and Response. The Commissioner is hereby authorized to charge any additional fees connected with this communication (including any extension of time fees) or credit any overpayment to Deposit Account No. 50-0208.

Respectfully submitted,

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**DOCKET NO. H0003936 US
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PATENT**

APPENDIX

**Copy of U.S. Patent Application Serial No. 10/608,467
(retrieved from USPTO Public PAIR system on 04-15-2008)**

CROSS-DIRECTION ACTUATOR AND CONTROL SYSTEM
WITH ADAPTIVE FOOTPRINT

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FIELD OF THE INVENTION

This invention relates to a control method and system for use with sheet-making equipment.

BACKGROUND OF THE INVENTION

10 Conventional sheet-making machinery for producing a continuous web or sheet of material includes equipment to set the sheet properties of the web as it is being manufactured. Generally, on-line measurements of sheet properties are made by scanning sensors that travel back and forth across the width of the sheet of material in the cross-machine direction (CD). The machine direction (MD) is the
15 direction of travel of sheet. The scanning sensors are located downstream of actuators that are controlled to adjust the sheet properties. The scanning sensors collect information about the sheet properties to develop a property profile across the sheet and provide control signals to the appropriate actuators to adjust the profile toward a desired target profile in a feedback loop. In practice, the actuators provide
20 generally independent adjustment at adjacent cross-directional locations of the sheet, normally referred to as slices.

25 In paper-making equipment, properties such as paper weight, thickness (caliper), smoothness, moisture content, and gloss are controlled by manipulating appropriate actuators to adjust the properties under the actuators' influence toward a desired goal.

30 High-performance cross-directional (CD) control of sheet-making machines, particularly, paper machines, requires accurate knowledge of the controlled process model. Particularly important for CD control is an accurate knowledge of the mapping between CD actuators and their response centre positions in the

measurement scan. Mapping involves establishing the relationship between each downstream slice where scanning measurements occur and the corresponding upstream actuator that must be adjusted to control the particular downstream slice. In practice, this mapping depends on the paper alignment and shrinkage, which vary

5 from one paper machine to another and with time for the same machine.

Even though mapping is used, conventional control systems still rely on actuators that have a fixed footprint that affects a particular slice of the sheet under manufacture. Only the magnitude of the actuator response is manipulated by

10 conventional control systems to adjust sheet properties and there is no attempt to dynamically manipulate response shape. In some cases, the actuator footprint shape may change but this change is not controlled directly and is a consequence of manipulation of the magnitude of the actuator response.

SUMMARY OF THE INVENTION

The method and system of the present invention involves:

- the use of an actuator that has 2 control dimensions: the magnitude of the actuator control action and the cross-direction footprint or shape of the actuator control action.
- the use of a controller that takes into account the measured process response from the actuator. The controller then calculates the best footprint or shape to minimize profile variation and then inputs this optimal response shape and magnitude to the actuator on an ongoing basis.

Accordingly, the present invention provides a method for controlling one or more properties of a sheet of material to be manufactured on a sheet-making machine that includes actuators to control the sheet properties arrayed in a cross-direction of the machine comprising the steps of:

- measuring properties data about the one or more properties of the sheet of material; and
- controlling both the magnitude of an actuator control action and the cross-direction shape of an actuator control action to minimize the variation of the measured properties data from a desired target for each of the one or more properties.

In a further aspect, the present invention provides a system for controlling one or more properties of a sheet of material to be manufactured on a sheet-making machine comprising:

- 25 a plurality of actuators distributed in the cross-machine direction over the sheet of material that are controllable to vary the properties of the sheet of material by varying both the magnitude of the actuator response and the cross-directional shape of the actuator response;
- scanners distributed over the sheet of material to measure properties data

about the properties of the sheet of material;

a controller in communication with the scanners for calculating control actions for each of the plurality of actuators and implementing appropriate control actions at the actuators such that the actuators co-operate to adjust the properties of

5 the sheet of material to desired targets.

The controller of the present invention takes into account the flat sheet process response of the material under manufacture and manipulates the two dimensions of the actuator control to optimize the manufacturing process. Both

10 actuator characteristics and flat-sheet process characteristics are taken into account when calculating control actions.

By directly controlling two dimensions of the actuator response via control actions to adjust both magnitude and footprint shape, the process and apparatus of the

15 present invention offers improved control over the manufacturing process. Without footprint shape control, there may be variation in the cross-direction in the sheet property being controlled that cannot be eliminated by adjusting only the magnitude of the actuator response. By optimizing the actuator footprint shape as well as magnitude, the controller for the system of the present invention can further reduce

20 variation in the sheet properties to better achieve a desired target property.

BRIEF DESCRIPTION OF THE DRAWINGS

Aspects of the present invention are illustrated, merely by way of example, in the accompanying drawings in which:

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Figure 1 is a schematic view of a paper-forming section of sheet-making equipment according to the present invention that relies on a slice lip to control the weight of the paper sheet under manufacture;

10 Figure 1A is a detail view of the slice lip of the paper-forming section shown in Figure 1;

15 Figure 1B is a detail schematic view in plan of an alternative head box arrangement that relies on dilution water to control the weight of the paper sheet under manufacture;

Figure 2 is a schematic view of a steam box arrangement incorporating the system and process of the present invention;

20 Figure 3 is a front view of a portion of the steam box arrangement of Figure 2 showing an embodiment that relies on movable baffle plates to control the shape of a steam actuator footprint;

25 Figure 3A is a detail view of a portion of the steam box screen showing an alternative embodiment that uses air jets for controlling the shape of a steam actuator footprint;

Figure 3B is a further detail view of a portion of the steam box screen showing a further embodiment, which relies on a movable screen to control the shape

of a steam actuator footprint;

Figure 4 is a schematic view of a water spray remoisturizer actuator for use with the present invention;

5

Figure 5 is a detail view of the water spray nozzle employed in the actuator of Figure 4;

Figure 6 is a schematic view of an induction heating coil actuator according to the present invention for use at the press or calendering section of a paper-making machine;

Figure 6A illustrates a cross-section through an induction heating coil actuator according to another embodiment of the present invention;

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Figure 6B is a view taken along line 6B-6B of Figure 6A showing individual wires of the windings;

Figure 7 is a schematic view of an electric infrared heating actuator for the present invention; and

Figure 8 is a cross-section view through a gas infrared emitter heating actuator designed to permit adjustment of the footprint shape of the actuator by virtue of movable screens.

25

DESCRIPTION OF THE PREFERRED EMBODIMENTS

The method and system of the present invention finds application at various stages of the sheet-making process from the initial paper forming and weight control

5 step through the pressing, drying, and calendering stages. It will be understood that the method and system of the present invention are not limited to use in association with any one stage or process. The method of the present invention can be used in conjunction with various types of actuators to control properties of a sheet under manufacture including, but not limited to, sheet weight, sheet caliper or thickness,

10 sheet moisture content, and sheet gloss. The following description provides specific examples of the manner in which the method of the present invention can be carried out to control two dimensions of actuator response: i) the magnitude of the actuator control action; and ii) the cross-direction footprint or shape of the actuator control action.

15

Referring to Figure 1, there is shown a schematic view of the initial section of a sheet-making machine 2, in the form of a paper-making machine, which operates to form the sheet of paper and establish the weight of the sheet. In the illustrated arrangement, formation of the paper sheet is influenced by a plurality of linear actuators 4 extending in the cross direction across the sheet 8 of paper being formed.

20 Sheet 8 is moving in the machine direction indicated by arrow 6. The general arrangement of Figure 1 is described in commonly owned United States Patent No. 5,096,542, which is incorporated herein by reference.

25 Actuators 4 control the sheet's weight in the cross direction. A sensor 10 is located downstream from the actuators and measures the properties of the sheet. A head box 12 stores stock, which is essentially a fibre suspension. The stock is fed from the head box through a gap or elongate orifice 14 onto a wire section 16. The orifice or gap is a relatively narrow opening that extends across the width 18 of the

machine. As best shown in Figure 1A, which is a detail view of the slice lip arrangement of Figure 1, the major components that make up the orifice comprise a bottom section, referred to as the apron 3, and a top section, referred to as the slice lip 7. Weight profile control in such an arrangement is achieved by locally adjusting 5 the position of the slice lip across the machine with motorized linear actuators 4 to vary the dimensions of the gap or orifice immediately adjacent the actuator. Upper slice lip 7 is mounted to a bar 9 that is movable, often by pivoting, using additional actuators 5 to globally adjust the slice lip and thereby the orifice in the cross machine direction.

10

Referring to Figure 1, downstream sensor 10 measures the weight of the sheet by, for example, scanning across the sheet in a conventional manner. In general, a specialized sensor in the form of a scanner will be located downstream of the actuators of interest to measure the relevant sheet property controlled by the 15 actuators. In other words, a plurality of scanners is located along the path of the sheet under manufacture after each set of actuators to provide measured data relevant to the property controlled by actuators. Alternatively, a sensor can be used to measure and collect data on multiple properties in one or more scanning passes.

20

Measured data from sensor 10 is communicated to a controller 20 via line 22. In the illustrated arrangement, controller 20 is associated only with the set of actuators 4 and 5 that control the weight of the paper. Alternatively, controller 20 can be an overall control unit that receives measurement data from various scanning stations and provides actuator control actions to different sets of actuators controlling 25 particular sheet properties.

In the arrangement illustrated in Figures 1 and 1A, controller 20 calculates control actions to communicate to each of the actuators 4, 5 in order to minimize the variation of the measured properties data from a desired target. Controller 10

calculates a first control action in order to vary the magnitude of the actuator response and a second control action to vary the cross-directional shape of the actuator response. For example, the first control action may involve a signal to each linear actuator 4 to locally adjust the gap 14 between slice lip 7 and apron 3. Each 5 actuator includes a threaded shaft connected at one end to bar 9 and at the opposite end to a motor to rotate the shaft. In this case, the first control action would be a signal to the motor to rotate the shaft to locally lower or raise the slice lip. The second control action would be a signal to actuators 5 to globally adjust the dimensions of orifice 14.

10

In the present case, the first and second control actions calculated by controller 20 are communicated to each actuator as first and second setpoints via lines 24, 26. The process of measuring sheet properties data by scanner is performed at regular intervals to provide feedback to the controller with respect to previous 15 control actions. When calculating the first and second control actions, controller 20 is programmed to take into account the characteristics of the actuator being controlled. In a similar manner, controller 20 is programmed to take into account the characteristics of the sheet being manufactured.

20

Figure 1B shows a different head box arrangement, which relies on dilution of the stock to influence the weight of the paper sheet being manufactured. Figure 1B is a plan view of the head box 12 with a sheet 8 being formed at the slice lip gap 14. At the end of the head box opposite the slice lip gap, there are a plurality of stock flow actuators 25 arrayed across the head box in the cross-machine direction that 25 distribute stock from a header fed by a stock source (not shown). Dilution water from a dilution header 27 is controllably injected into each stock flow actuator 25 via dilution lines 28. For reasons of clarity, only two dilution lines 28 are illustrated. It will be appreciated that each stock flow actuator 25 has an associated dilution line 28. Under normal practice, stock flow actuators 25 include a restriction to limit flow.

Preferably, in the embodiment of the present invention, each line 28 includes a valve 29 to control the flow of dilution water. In this arrangement, the first control action to vary the magnitude of the control response comprises individual adjustment via conventional actuators at each valve 29 to control the volume of dilution water

5 through each actuator. The second control action to vary the footprint of the control response at each actuator involves controlling the pressure of injection of the dilution water delivered to each stock flow actuator 25. Controlling the pressure of injection of the dilution water controls the degree of mixing of the stock in the head box, which tends to change the apparent consistency profile of the stock. Global

10 adjustment of the pressure of the dilution water is achievable by changing the pressure in dilution header 27 relative to pressure of stock in actuators 25. Individual adjustment of the pressure to a particular stock flow actuator 25 is achieved by controlling an actuator in the form of a pump or regulator in each line 28.

15 By way of further example, the method and system of the present invention finds application in other aspects of the paper-making process apart from the initial establishment of the paper basis weight.

In the case of the press and calendering sections of a paper-making machine,

20 steam may be added to the paper sheet under manufacture by a steam box. The steam condenses on the sheet to release its thermal energy to the sheet. The present invention finds application in a modified steam box arrangement. Referring to Figure 2, there is shown schematically a view of a steam box 30, which extends in the cross-machine direction adjacent sheet 8, which is traveling in the direction

25 indicated by arrow 6 under the influence of a rotating roll 7. Each steam box 30 defines a plurality of control zone 32 or "slices" of sheet 8 within which the steam box is able to control the delivery of steam to the sheet. As in conventional steam box equipment, a source of steam 34 delivers steam to steam box 30 via a steam supply manifold 36 that extends in the cross-machine direction. A sensor (not

shown) regularly measures the moisture content of the sheet in the cross-direction at a location downstream of the steam boxes. The measured moisture content sheet property data is then fed to the controller of the present invention. The controller determines how the measured moisture profile of the sheet 8 needs to be adjusted to

5 move the actual profile toward a target profile and generates appropriate control actions. As with conventional systems, the volume of steam flow to each control slice 32 is varied to control the magnitude of the control action at a particular cross direction location. Steam box 30 is formed with a plurality of steam outlet chambers for releasing steam to each control slice of the sheet of material. In the present

10 invention, the steam outlet chambers are also manipulatable in terms of outlet chamber position and dimensions to control the cross-direction shape of the control action and, thereby, the shape of each control zone 32.

A screen 38 at the front of the steam box delivers steam from steam box 30 to

15 condense on the sheet under manufacture to release the steam's thermal energy to the sheet. A plurality of conventional steam nozzles 40 to the rear of steam box 30 receive steam via manifold 36. Each steam nozzle 40 defines a control slice 32 of the steam box 30. Associated with each steam nozzle is an actuator 37 and an outlet chamber 42 just behind screen 38. Each actuator 37 adjusts the volume of steam

20 flow to its associated steam nozzle 40 and thereby to associated outlet chamber 42 just behind screen 38. Figure 3 shows a partial front view looking at a portion of screen 38 according to an embodiment of the present invention. In this arrangement, outlet chamber 42 behind screen 38 includes movable baffle plates 42B that are movable between spaced, outer walls 42A of the outlet chamber to adjust the position

25 and size of the outlet chamber about centrally-located steam nozzle 40. An actuator motor 44 working through an appropriate mechanical linkage 44A is used to manipulate the cross-direction position of baffle plates 42B and thereby the position and dimensions of the outlet chamber. In Figure 3, baffle plates 42B are shown spaced away from outer side walls 42A of the outlet chamber and closer to central

steam nozzle 40 to create a smaller footprint for control slice 32. Baffle plates 42B can also be moved adjacent outer side walls 42A to maximize the size of outlet chamber 42 and control slice 32.

5 In an alternative arrangement illustrated in Figure 3A, each outlet chamber 42 includes at least one air jets 45. In Figure 3A, two air jets are shown mounted to opposite side walls 42A of the outlet chamber, however, other arrangements are possible and would be obvious to a person skilled in the art. Air jets 45 are discharged to control the dispersal pattern of the steam through the openings in
10 screen 38. Varying the air flow volume or pressure will permit control of the dispersal pattern of steam from each outlet chamber with a resulting controlled change in the footprint of actuator. For example, no air flow through air jets 45 will allow steam from nozzle 40 to disperse fully within outlet chamber 42 and the control slice 32 will attain a maximum size. By discharging air through jets 45, the
15 steam will tend to be compressed into a smaller footprint.

Figure 3B shows a still further alternative arrangement for controlling the shape of the steam actuator footprint. Figure 3B is also a detail view of a portion of the front of screen 38. Screen 38 covering outlet chamber 42 includes a plurality of
20 openings 46 therethrough to allow for passage of steam from the chamber to the sheet. At least one movable plate 48 is positioned below screen 38 within outlet chamber 42. In the illustrated embodiment, two movable plates 48 (in dashed lines) are shown adjacent each outer side wall 42A of the outlet chamber below screen 38. In this case, the step of manipulating the cross-direction shape of the actuator control
25 action involves adjusting the position of movable plates 48 with respect to screen 38 to fully or partially obstruct the openings 46 in the screen 38 to control the release of steam through those openings. Movable plates 48 are preferably formed with their own openings that are alignable or misalignable with openings 46 in screen 38. Preferably, each movable plate 48 is controlled by a motor 49 that acts to move plate

48 between the position shown in Figure 3B, in which the openings in the screen and the plates are aligned for control footprint of maximum size, and other positions, in which the openings are partially or fully misaligned to reduce the footprint of the steam actuator.

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Moisture can be added to a paper sheet by nozzle actuators, which spray water atomized by air pressure onto the sheet. By way of example, commonly owned United States Patent No. 6,334,579, entitled AIR ATOMIZING NOZZLE, discloses an example of such a nozzle assembly which is sold under the trademark

10 AQUALIZER by Honeywell ASCa of North Vancouver, Canada. The disclosure of the '579 patent is incorporated herein by reference. An array of nozzles is mounted in a spray boom that extends across the sheet in the cross direction. Figure 4 is a cross-section view through a spray boom 50 showing the details of an exemplary nozzle actuator. Each nozzle assembly 52 comprises a housing 51 having an air inlet 15 54 for connection to an air pressure source 56, a liquid inlet 58 for connection to a liquid source 60, and a nozzle outlet 62. Nozzle outlet delivers atomized water 64 to paper sheet 8 in a spray pattern that defines the footprint of the nozzle actuator. In the illustrated arrangement, the cross-direction shape of the spray pattern can be manipulated by adjusting the air pressure or air flow delivered to the nozzle via air 20 supply 56.

Figure 5 provides a detail cross-section view through housing 51 of the water spray nozzle described in United States Patent No. 6,334,579. The nozzle includes an outer casing 68 into which is introduced an insert 70. Water under pressure from 25 supply line 60 is delivered to a central liquid passage 72 through insert 70. Pressurized air from air supply 56 is delivered to an annular air passage 74 created between insert 70 and outer casing 68. The outer surface of insert 70 is formed with a plurality of channels in a spiral configuration that terminate adjacent the tip 76 of the insert. The spiral channels act to swirl a portion of the air travelling through

annular air passage 74 immediately adjacent the insert while the remainder of the air flow maintains a linear flow pattern through the passage. The air passage and the liquid passage terminate, respectively, at an air discharge opening 77 and a water discharge opening 79 in a common atomization zone 80 at nozzle outlet 62 where

5 liquid flowing through the liquid passage is atomized into a consistent spray pattern with good water atomization over a wide range of water flow rates. The water flow rate is adjusted via a first control action to modify the magnitude of nozzle actuator response by virtue of varying the volume of water delivered to the sheet. In order to adjust the shape of the spray pattern, the system of the present invention provides an

10 actuator associated with each nozzle to permit adjustment in the position of water discharge opening 79 with respect to air discharge opening 77. In the illustrated embodiment, this is accomplished by way of a motor 82 that acts to move nozzle insert 70 within outer casing 68. In other words, the second control action to modify the shape of the spray pattern for the illustrated nozzle involves sending a signal to

15 motor 82 to adjust the position of the insert 70 within casing 68. In general, if water pressure and air pressure are maintained constant, forward movement of nozzle insert 70 with respect to outer casing 69 will tend to result in a spray pattern of smaller diameter at the sheet under manufacture while rearward movement of the nozzle insert will result in a spray pattern of larger diameter.

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In the case of the calendering section of a paper-making machine, where the paper sheet passes between rolls to adjust the thickness (caliper) of the paper, the nip or gap between adjacent rolls can be controlled by induction heating coil actuators. The heating coil actuators heat control zones on one or more of the rolls to increase

25 the diameter of the rolls within each zone and thereby decrease the gap between the rolls. This system establishes a gap profile in the cross direction which is imparted to a paper sheet fed between rolls. By way of example, United States Patent No. 4,384,514, entitled NIP CONTROL METHOD AND APPARATUS, discloses an example of such an induction heating apparatus which is sold under the trademark

Calcoil by Honeywell ASCa of North Vancouver, Canada.

Referring to Figure 6, there is shown schematically, a plurality of induction heating coil actuators 90 which are arranged in the cross machine direction adjacent a nip roll 92 of a pair of rolls 92, 93 in the calendering section of a paper-making machine. As is conventional, induction heating coil actuators 90 are activated to heat the exterior of nip roll 92 to induce a local change in diameter of the roll within a zone or control "slice" influenced by each heating coil. The local change in diameter of the nip roll 92 results in a local change in the dimensions of the gap 94 between the rolls. The thickness of the sheet material that is fed between the rolls will be affected depending on the dimensions of gap profile.

In the arrangement of the present invention, each induction heating coil is mounted for pivotable movement. As is conventional, the first control action according to the present invention involves adjusting the current to the coils to cause induction heating that produces a desired increase in the diameter of the nip roll 92. The second control action to adjust the cross-direction shape of the actuator control slice comprises adjusting the angle of the heating coil which affects the shape of the control slice at the nip roll 92.

Alternatively, the induction heating coils of the present invention can be formed with multiple windings for generating different magnetic field geometries. The second control action to manipulate the cross-direction shape of the actuator control action comprises controlling the current in an appropriate winding to create a control slice of the desired shape. For example, Figure 6A illustrates a cross-section through an induction heating coil actuator 90, which includes windings A and B. Figure 6B is a view taken along line 6B-6B of Figure 6A showing individual wires of the windings arranged in groups by virtue of the configuration of the coil windings. If current is delivered to the wires of both windings A and B, it is apparent actuator

90 will have a magnetic field footprint of maximum extent that includes the contribution of both groups of wires. Alternatively, if current is delivered to only one winding, the magnetic field footprint of the actuator will be reduced in size. Furthermore, changing the footprint is not limited to delivering or not delivering

5 current to a particular winding. It is also possible to vary the amount of the current delivered to each winding to vary the footprint. For example, winding A can receive a different current from that delivered to winding B to adjust the magnetic field footprint of the actuator.

10 Moisture can be removed from the paper sheet under manufacture using an infrared heating actuator comprising a series of infrared heating lamps. An example of such an infrared heating apparatus is sold under the trademark INFRATROL by Honeywell ASCa of North Vancouver, Canada. Figure 7 illustrates an example of an infrared heating actuator, which comprises a series of elongate infrared heating lamps

15 100 mounted between a ceramic backing and a protective quartz plate. In the illustrated example, each infrared lamp 100 comprises a 2kW bulb, and twelve bulbs define a control zone 102 that is six inches wide in the cross-machine direction. In the arrangement of the present invention, the first control action comprises setting a base or average voltage for all the lamps in a zone 102 to create an appropriate

20 heating action. This can be achieved by adjusting the applied voltage to the lamps or by applying the power in a duty cycle to the lamps. The second control action for manipulating the cross-direction shape of each control zone comprises controlling the voltage of each individual heating lamp to adjust the control zone dimensions. For example, the outermost lamps in a control zone may be set to a lower voltage or a

25 different power duty cycle to reduce the effective footprint of the control action. The voltage to lamps in different, but adjacent control zones may be co-ordinated to enlarge the control zone footprint or to shift the footprint in a desired direction. For example, one or more lamps at one side of a first control zone may be operated at the same voltage as the lamps in a second, adjacent control zone to effectively increase

the footprint of the second control zone. Similarly, one or more lamps at each side of a middle control zone may be operated at voltages corresponding to the lamps of adjacent control zones on either side of the middle zone to effectively shift the footprints of the control zones in the cross-machine direction.

5

Moisture can also be removed from the paper sheet under manufacture using actuators in the form a series of independently controllable gas-fired infrared matrix emitters that are positioned over the paper web in the cross-machine direction. By way of example, commonly owned United States Patent No. (currently allowed 10 application No. 09/775,391) entitled INFRARED HEATER discloses an example of such an infrared heating matrix, which is sold under the trademark INFRAZONE by Honeywell ASCa of North Vancouver, Canada. The disclosure of the '391 application is incorporated herein by reference.

15 Referring to Figure 8, there is shown a cross-section view through a gas-fired infrared matrix emitter actuator according to the present invention. Each gas-fired infrared matrix emitter actuator comprises a porous refractory ceramic matrix 110 that is fitted into a metallic housing 112. A plurality of housings is positioned side by side to extend across the web adjacent a sheet 8 under manufacture. The porous 20 ceramic matrix is bonded to the housing with silicone to define a plenum chamber 114. The plenum chamber of the housing is supplied with an air/fuel mixture via an inlet 116 that connects to a fuel supply (not shown). Gaseous fuel in the form of natural gas or propane is mixed with air according to a stoichiometric ratio, which is preferably about 1:10 to create the air/fuel mixture. Combustion occurs only on the 25 outer 1mm of the ceramic matrix to provide fast heatup times of about five seconds and fast cooldown times of about one second. This behaviour is essentially due to the ability of infrared emitting particles incorporated in the matrix 110 to radiate the heat generated, thus preventing the combustion flames from destroying the matrix by melting.

In the present invention, each matrix emitter actuator includes screen plates 118, 119 with openings 120 therethrough adjacent emitter matrix 110. Main screen plate 118 is fixed in position within the plenum chamber 114 while smaller, movable

5 screen plates 119 are positioned at opposite ends of the chamber. Screen plates 119 are movable by control motors 122 with respect to main screen plate 118 to fully or partially align or misalign openings 120 in the plates. In this arrangement, the second control action for manipulating the shape of the actuator footprint involves controlling the position of screens 119 to control the gas supply to the emitter matrix.

10 In the illustrated embodiment, movable screens 119 are positioned adjacent the end walls 121 of housing 112 with openings aligned with the openings in fixed main screen 118. In this configuration, the air/fuel mixture is free to disperse across the full extent of the emitter matrix 110 to obtain the maximum size of the control footprint. If movable screens 119 are moved inwardly away from side walls 121 by

15 motors 122, the openings in the screens will misalign to reduce the size of the control footprint of the actuator as the gas/fuel mixture is prevented from reaching the outer edges of the emitter matrix.

Although the present invention has been described in some detail by way of

20 example for purposes of clarity and understanding, it will be apparent that certain changes and modifications may be practised within the scope of the appended claims.

I claim:

1. A method for controlling one or more properties of a sheet of material to be manufactured on a sheet-making machine that includes a plurality of actuators to control the sheet properties arrayed in a cross-direction of the machine comprising the steps of:

measuring properties data about the one or more properties of the sheet of material; and

manipulating both the magnitude of each actuator control action and the cross-direction shape of each actuator control action to minimize the variation of the measured properties data from a desired target for each of the one or more properties.

15

2. The method as claimed in claim 1 in which the step of measuring properties data is done by a plurality of scanners.

20

3. The method as claimed in claim 1 including the step of communicating the measured properties data to a controller.

4. The method as claimed in claim 3 including the step of calculating the control actions at the controller to communicate to each of the actuators.

25

5. The method as claimed in claim 4 in which the step of measuring properties data is performed at regular intervals to provide feedback to the controller with respect to previous control actions.

6. The method as claimed in claim 5 in which the step of calculating control

actions involves calculating a first control action that permits variation of the magnitude of the actuator response and a second control action that permits variation in the cross-directional shape of the actuator response.

- 5 7. The method as claimed in claim 6 in which the first and second control actions are communicated to each actuator as first and second setpoints for each actuator.
8. The method as claimed in claim 6 in which the step of calculating control actions is performed taking into account actuator characteristics.
- 10 9. The method as claimed in claim 6 in which the step of calculating control actions is performed taking into account sheet characteristics.
- 15 10. The method as claimed in claim 1 in which each actuator comprises a steam actuator having an outlet chamber for releasing steam to the sheet of material, and the step of manipulating the cross direction shape of the actuator control action comprises manipulating the cross-direction position and dimensions of the outlet chamber.
- 20 11. The method as claimed in claim 10 in which the outlet chamber includes at least one movable baffle plate within the outlet chamber, and manipulating the cross-direction position and dimensions of the outlet chamber comprises moving the at least one movable baffle plate.
- 25 12. The method as claimed in claim 1 in which each actuator comprises a steam actuator having an outlet chamber for releasing steam to the sheet of material including a screen plate with openings therethrough covering the outlet chamber and at least one movable plate, and the step of manipulating the cross-direction shape of

the actuator control action comprises moving the at least one movable plate with respect to the screen plate to fully or partially obstruct the openings in the screen plate.

5 13. The method as claimed in claim 1 in which each actuator comprises a steam actuator having an outlet chamber for releasing steam to the sheet of material including at least one air jet associated with the outlet chamber, and the step of manipulating the cross-direction shape of the actuator control action comprises discharging the air jets to control the steam dispersal.

10

14. The method of claim 1 in which each actuator comprises a nozzle for delivering water atomized by air pressure to the sheet of material, and the step of manipulating the cross-direction shape of the actuator control action comprises adjusting the air pressure at the nozzle.

15

15. The method of claim 1 in which each actuator comprises a nozzle for delivering water atomized by air pressure to the sheet of material, and the step of manipulating the cross-direction shape of the actuator control action comprises adjusting the air flow at the nozzle.

20

16. The method of claim 1 in which each actuator comprises a nozzle for delivering water atomized by air pressure to the sheet of material, and the step of manipulating the cross-direction shape of the actuator control action comprises adjusting the position of a water discharge opening of the nozzle with respect to an air discharge opening of the nozzle.

25
17. The method of claim 1 in which each actuator comprises an induction heating coil for heating at least one of a pair of rolls to change the diameter of the at least one roll in order to vary the gap between the pair of rolls and thereby the thickness of a

sheet of material passing between the rolls with each heating coil having multiple windings for generating magnetic fields, and the step of manipulating the cross-direction shape of the actuator control action comprises controlling the current to the windings.

5

18. The method of claim 1 in which each actuator comprises an induction heating coil for heating at least one of a pair of rolls to change the diameter of the at least one roll in order to vary the gap between the pair of rolls and thereby the thickness of a sheet of material passing between the rolls with each heating coil being mounted for 10 pivotable movement, and the step of manipulating the cross-direction shape of the actuator control action comprises adjusting the angle of the heating coil.

19. The method of claim 1 in which each actuator comprises an array of infrared heating lamps for heating the sheet of material, and the step of manipulating the 15 cross-direction shape of the actuator control action comprises controlling the voltage of each heating lamp.

20. The method of claim 1 in which each actuator comprises a gas-fired infrared emitter matrix for generating infrared radiation to heat the sheet of material, the 20 emitter matrix being heated by combusting gas and having screen plates with openings therethrough adjacent the emitter matrix, and the step of manipulating the cross-direction shape of the actuator control action comprises moving the screen plates with respect to each other to fully or partially align or misalign openings in the screen plates thereby controlling the gas supply to the emitter matrix.

25

21. A system for controlling one or more properties of a sheet of material to be manufactured on a sheet-making machine comprising:

a plurality of actuators distributed in the cross-machine direction over the

sheet of material that are controllable to vary the properties of the sheet of material by varying both the magnitude of the actuator response and the cross-directional shape of the actuator response;

5 scanners distributed over the sheet of material to measure properties data about the properties of the sheet of material;

 a controller in communication with the scanners for calculating control actions for each of the plurality of actuators and implementing appropriate control 10 actions at the actuators such that the actuators co-operate to adjust the properties of the sheet of material to desired targets.

22. The system of claim 21 in which each actuator comprises a steam actuator having an outlet chamber for releasing steam to the sheet of material with the cross- 15 direction position and dimensions of each outlet chamber being manipulatable to control the cross-direction shape of the actuator response.

23. The system of claim 22 in which the outlet chamber of the steam actuator includes at least one movable baffle plate which is movable to control the cross- 20 direction position and dimensions of the outlet chamber.

24. The system of claim 21 in which each actuator comprises a steam actuator having an outlet chamber for releasing steam to the sheet of material and including a screen plate with openings therethrough covering the outlet chamber and at least one 25 movable plate, such that moving the at least one movable plate with respect to the screen plate acts to fully or partially obstruct openings in the screen plate.

25. The system of claim 21 in which each actuator comprises a steam actuator having an outlet chamber for releasing a flow of steam to the sheet of material

including at least one air jet associated with the outlet chamber dischargable to control the shape of the steam flow.

26. The system of claim 21 in which each actuator comprises a nozzle for delivering a water spray atomized by air pressure to the sheet of material including means for adjusting the air pressure at the nozzle to control the shape of the water spray.
27. The system of claim 21 in which each actuator comprises a nozzle for delivering a water spray atomized by air pressure to the sheet of material including means for adjusting the air flow at the nozzle to control the shape of the water spray.
28. The system of claim 21 in which each actuator comprises a nozzle for delivering a water spray atomized by air pressure to the sheet of material, the nozzle having an water discharge opening and an air discharge opening that are adjustable by position with respect to each other to control the shape of the water spray.
29. The system of claim 21 in which each actuator comprises an induction heating coil for heating at least one of a pair of rolls to change the diameter of the at least one roll in order to vary the gap between the pair of rolls and thereby the thickness of a sheet of material passing between the rolls with each coil having multiple windings for generating magnetic fields whereby controlling the currents to each of the multiple windings controls the cross-direction shape of the actuator response.
30. The system of claim 21 in which each actuator comprises an induction heating coil for heating at least one of a pair of rolls to change the diameter of the at least one roll in order to vary the gap between the pair of rolls and thereby the thickness of a sheet of material passing between the rolls, each heating coil being

mounted for pivotable movement whereby adjusting the angle of the heating coil controls the cross-direction shape of the actuator response.

31. The system of claim 21 in which each actuator comprises an array of infrared
5 heating lamps for heating the sheet of material whereby controlling the voltage of
each heating lamp controls the cross-direction shape of the actuator response.

32. The system of claim 21 in which each actuator comprises a gas-fired infrared
emitter matrix for generating infrared radiation to heat the sheet of material, the
10 emitter matrix being heated by combusting gas and having screen plates with
openings therethrough adjacent the emitter matrix, whereby moving the screen plates
with respect to each other to fully or partially align or misalign openings in the screen
plates acts to vary the gas supply to the emitter matrix to control the cross-direction
shape of the actuator response.

15

33. The method as claimed in claim 1 in which each actuator comprises a motor
for controlling the position of a slice lip mounted to a head box, and the step of
manipulating the cross direction shape of the actuator control action comprises
manipulating the global position of the slice lip.

20

ABSTRACT OF THE DISCLOSURE

A method and system for controlling one or more properties of a sheet of material to be manufactured on a sheet-making machine is disclosed. Actuators to 5 control the sheet properties are arrayed in the cross-direction of the machine.

Properties data about one or more properties of the sheet of material are measured and both the magnitude of an actuator control action and the cross-direction shape of an actuator control action are controlled to minimize the variation of the measured properties data from a desired target for each of the one or more properties.

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CONTROL SYSTEM WITH ADAPTIVE FOOTPRINT
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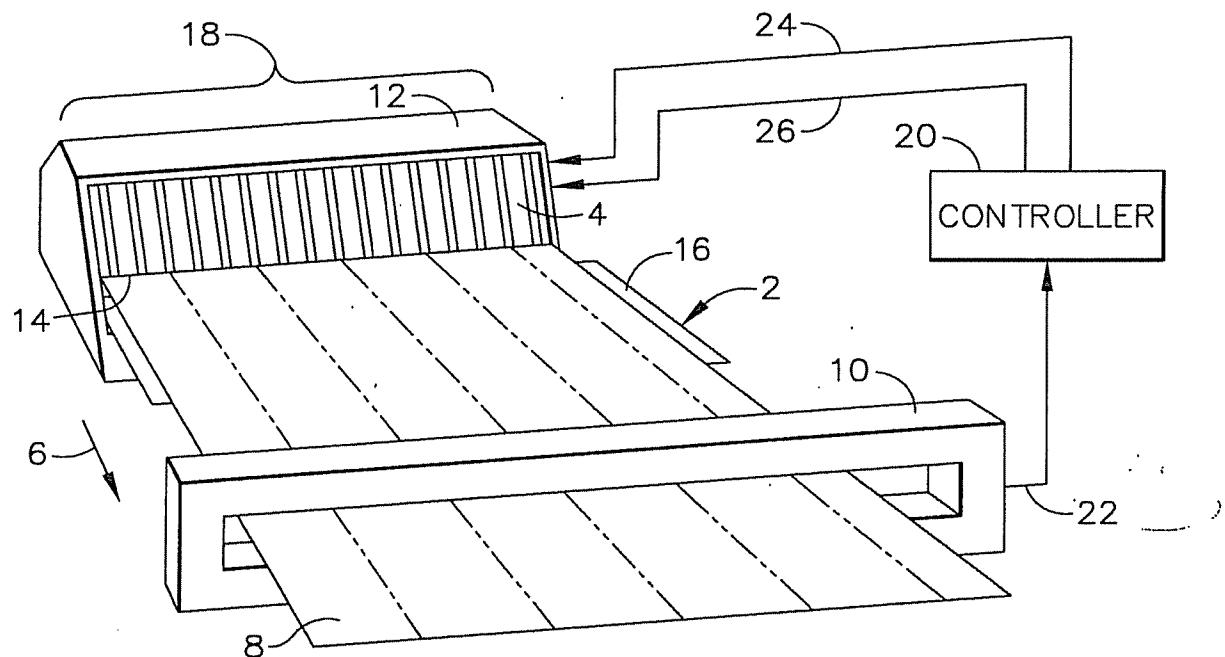


FIG. 1

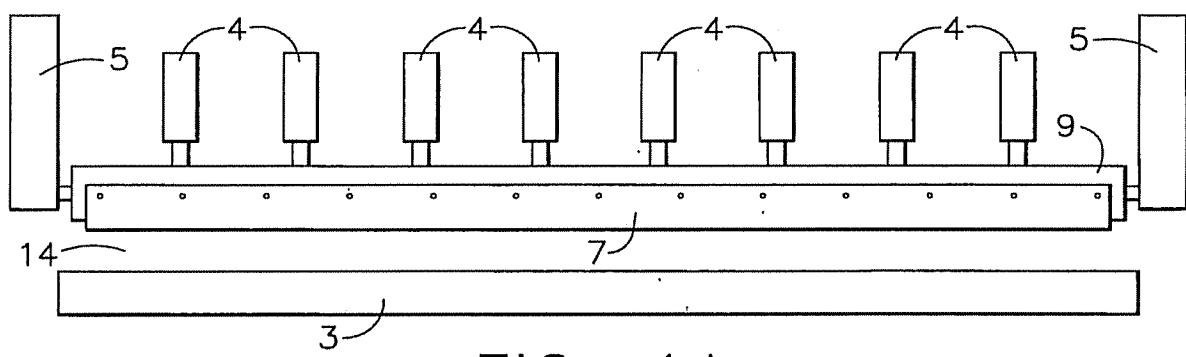


FIG. 1A

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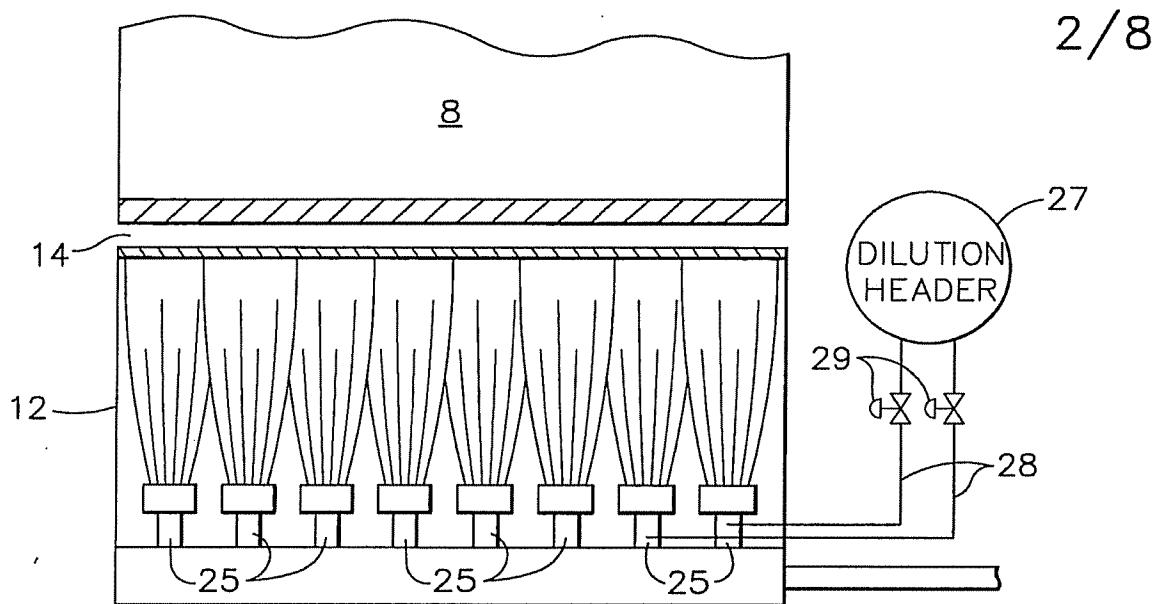


FIG. 1B

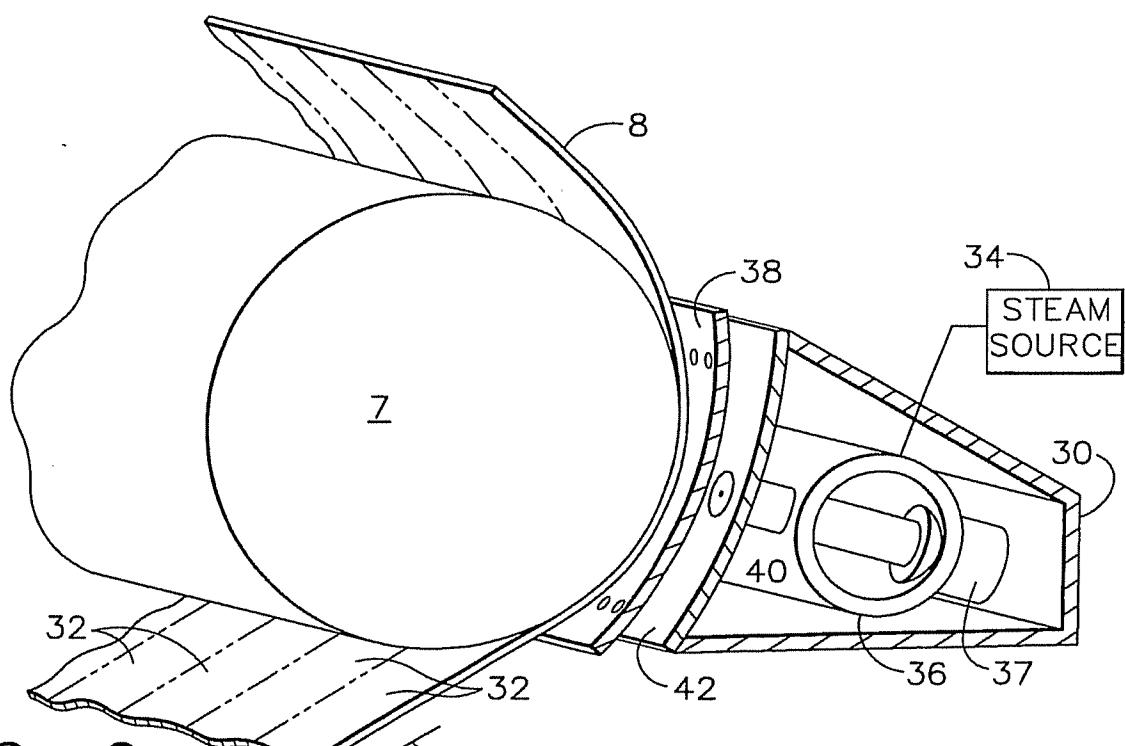


FIG. 2

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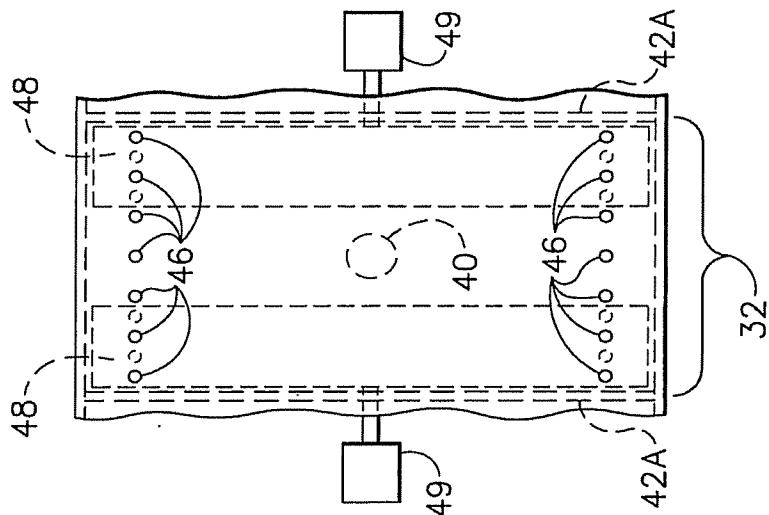


FIG. 3B

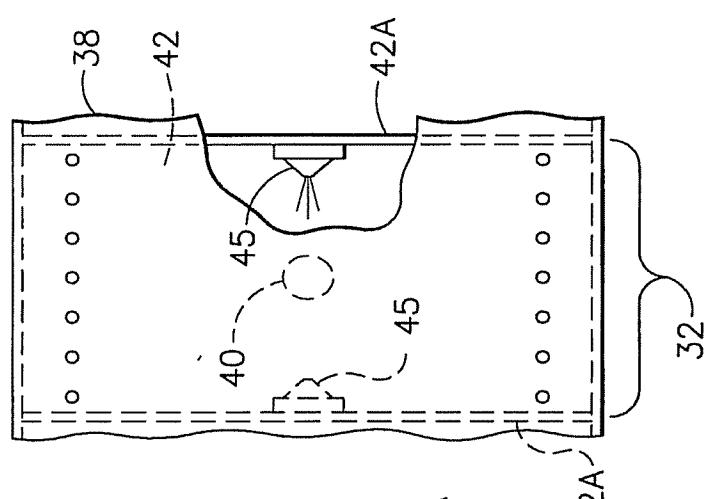


FIG. 3A

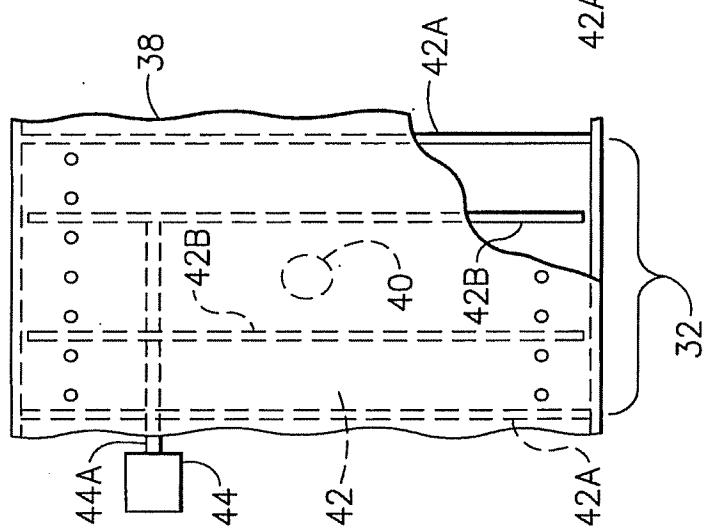


FIG. 3

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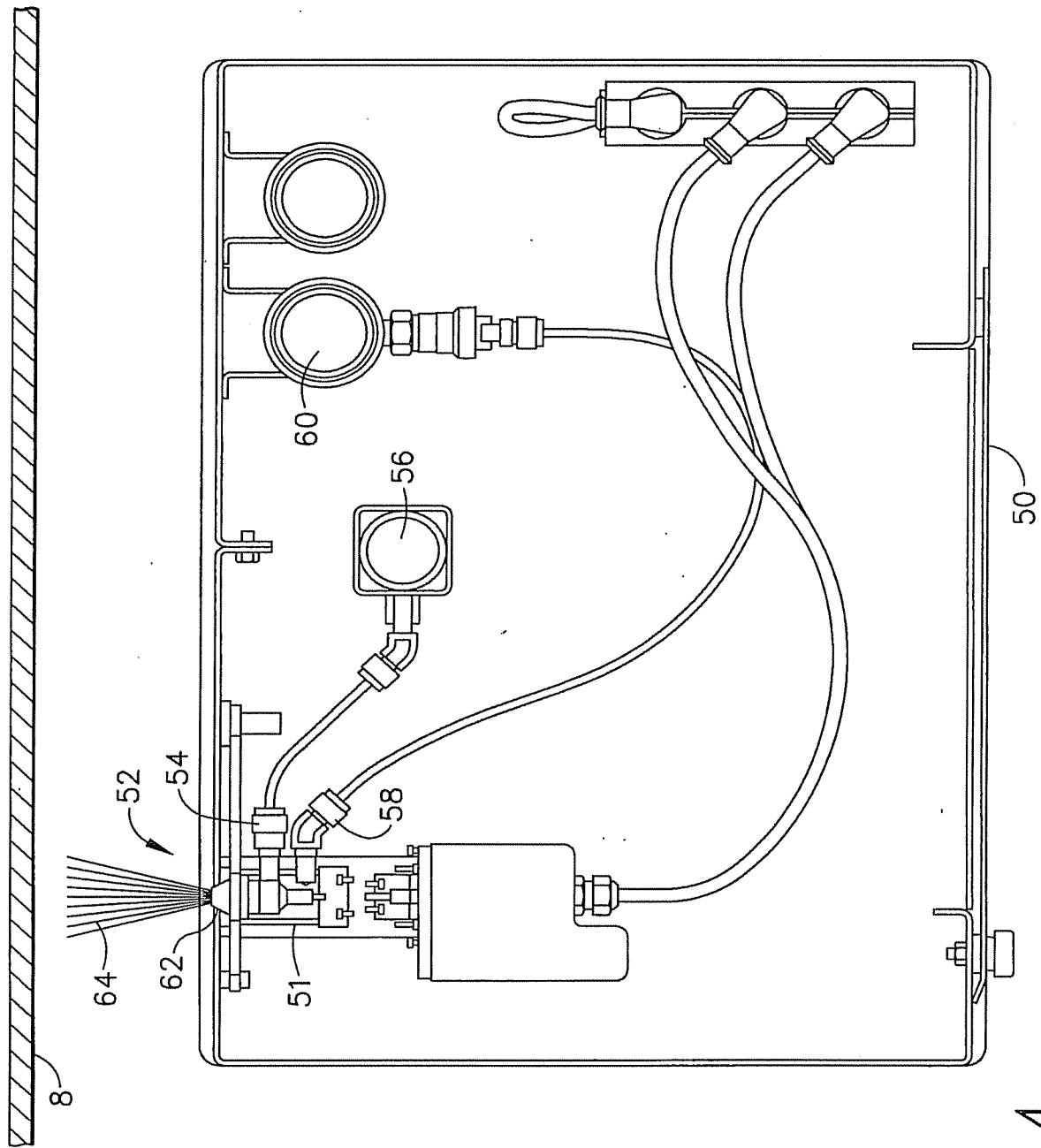
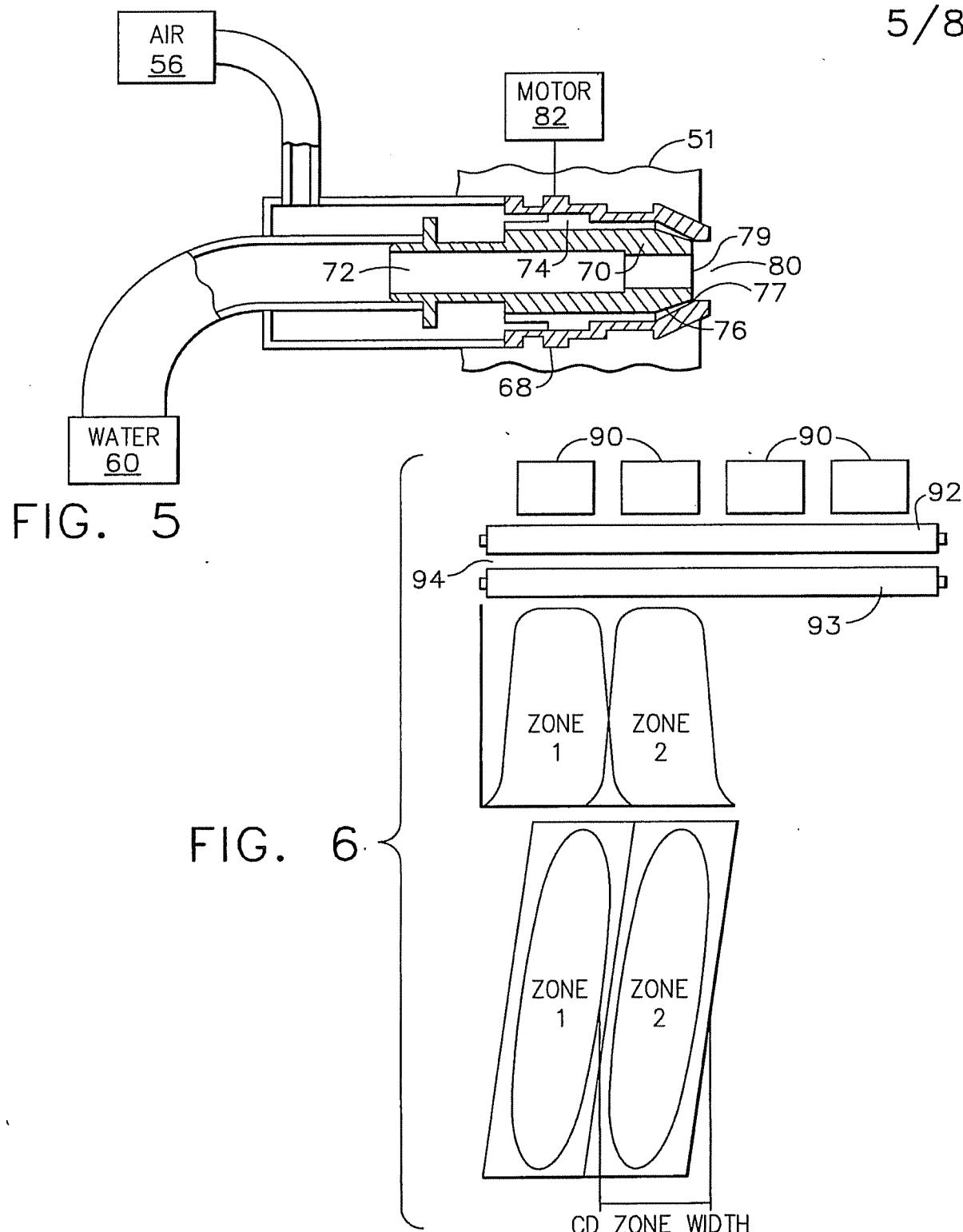


FIG. 4

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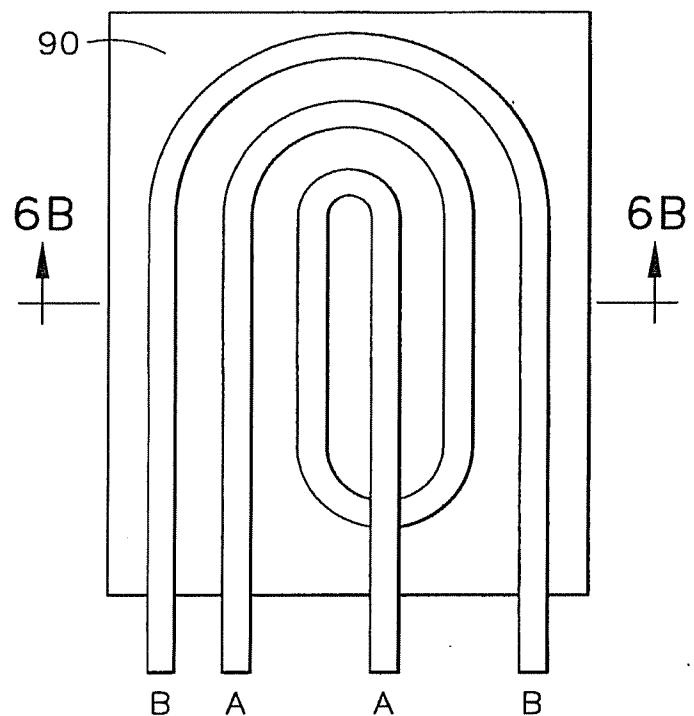


FIG. 6A

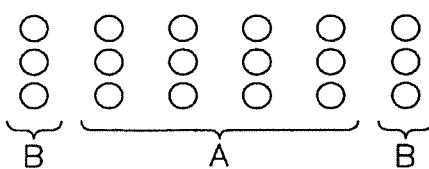


FIG. 6B

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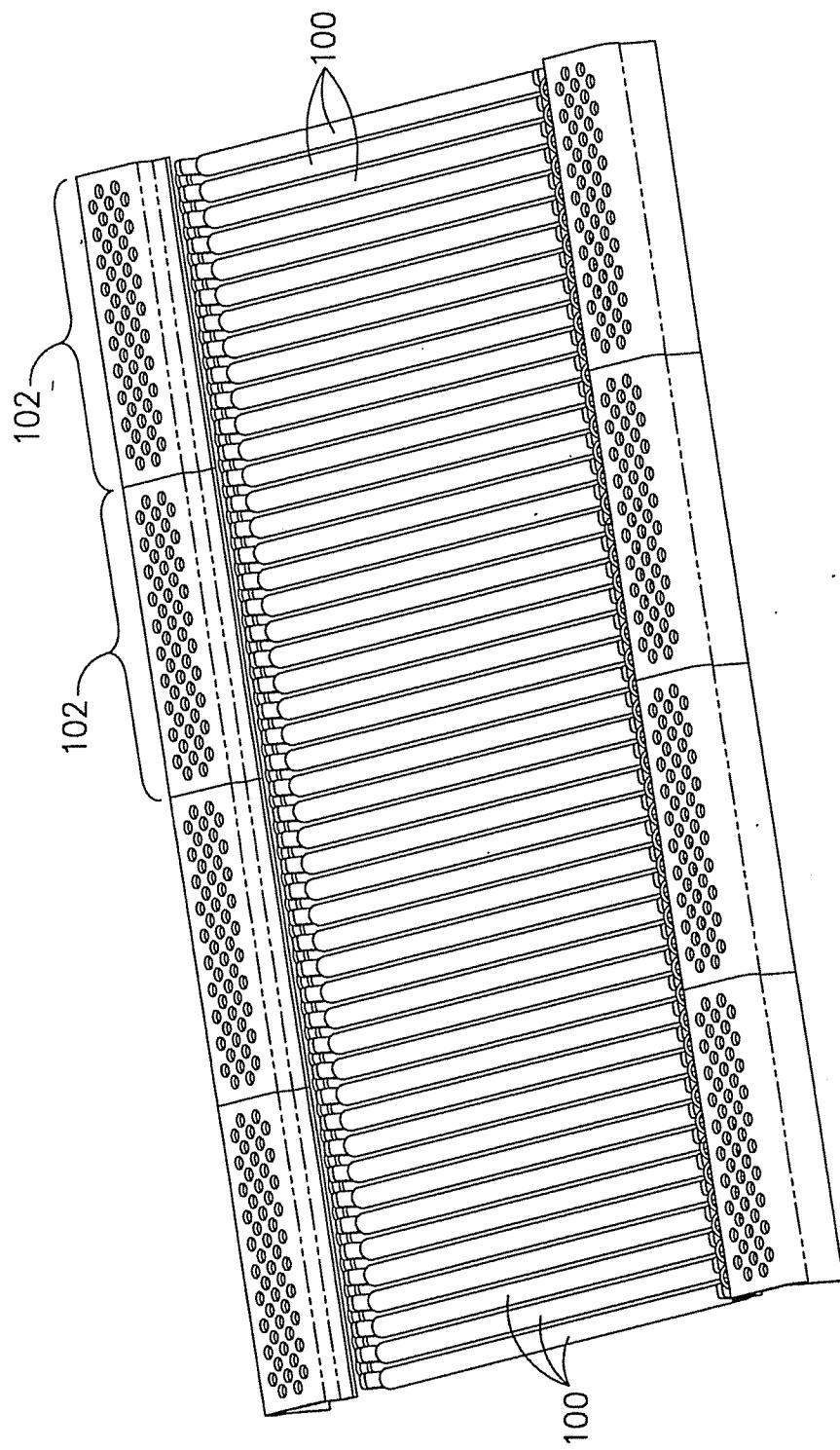


FIG. 7

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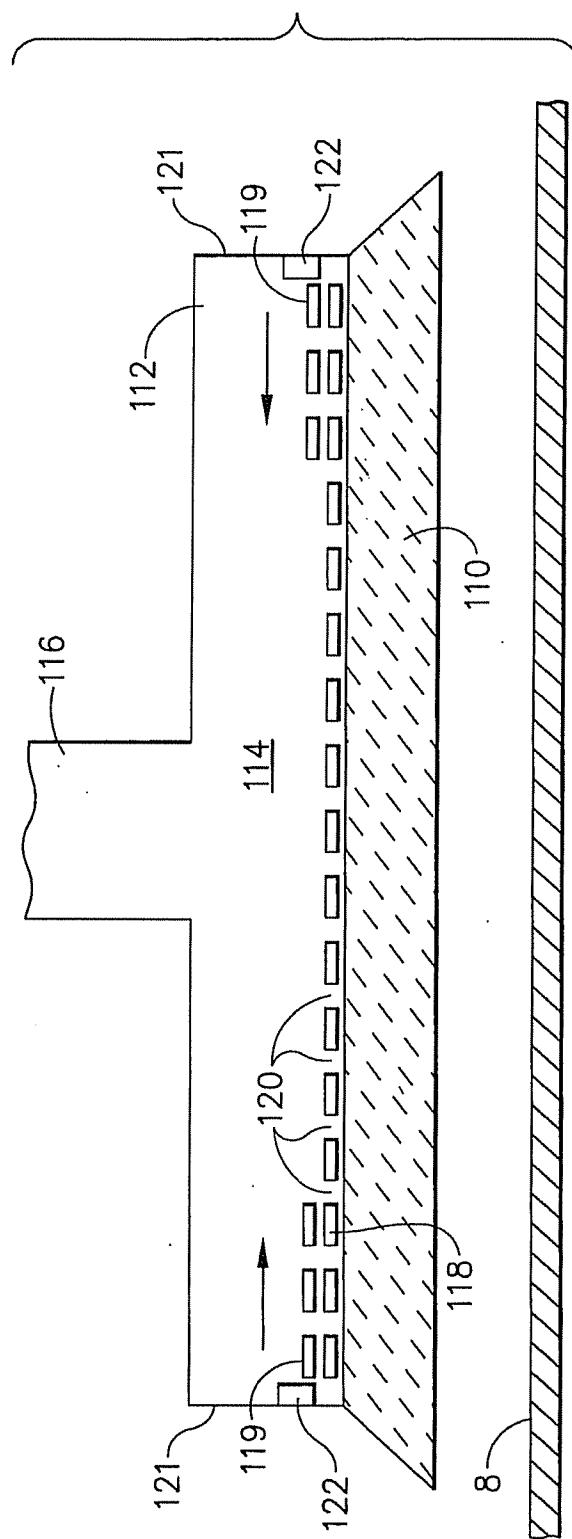


FIG. 8